



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

D5736-045
Job Sheet 203343

Accounting Job RD19-1069-01



POSITIVE RECALL

EFFECTIVE 9/11/13 AUTH AS

RELEASED 9 DATE 19.11.13

Priority: Medium
ok Release

Part No: D5736-045

Job Qty: 2 pcs

Part Name: AFT Wearbar Assembly



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1206 DWG D5736 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy- 1	2 pcs	11/29/19	11/29/19	0.00	0.08	Large Fab - 1		<i>EL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Automated Welding - B4B	2 pcs	11/29/19	11/29/19	0.00	1.56	Automated Welding - 1 - B4B		<i>MF</i>
120	QC 10	2 pcs	11/29/19	11/29/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		<i>EL</i>
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S235837



Part: D5736-045

Job No: 203343

Serial No/Batch: S235837

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/28/19

Plex 11/15/19 10:53 AM Dart.lajeunesse.marie

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140	Packaging 3-1 - Stock - B4B	2 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	EL
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	2 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	
					QC 21 - SA - 53	

POSITIVE
RECALL
DAS
9
9-89
19.11.23

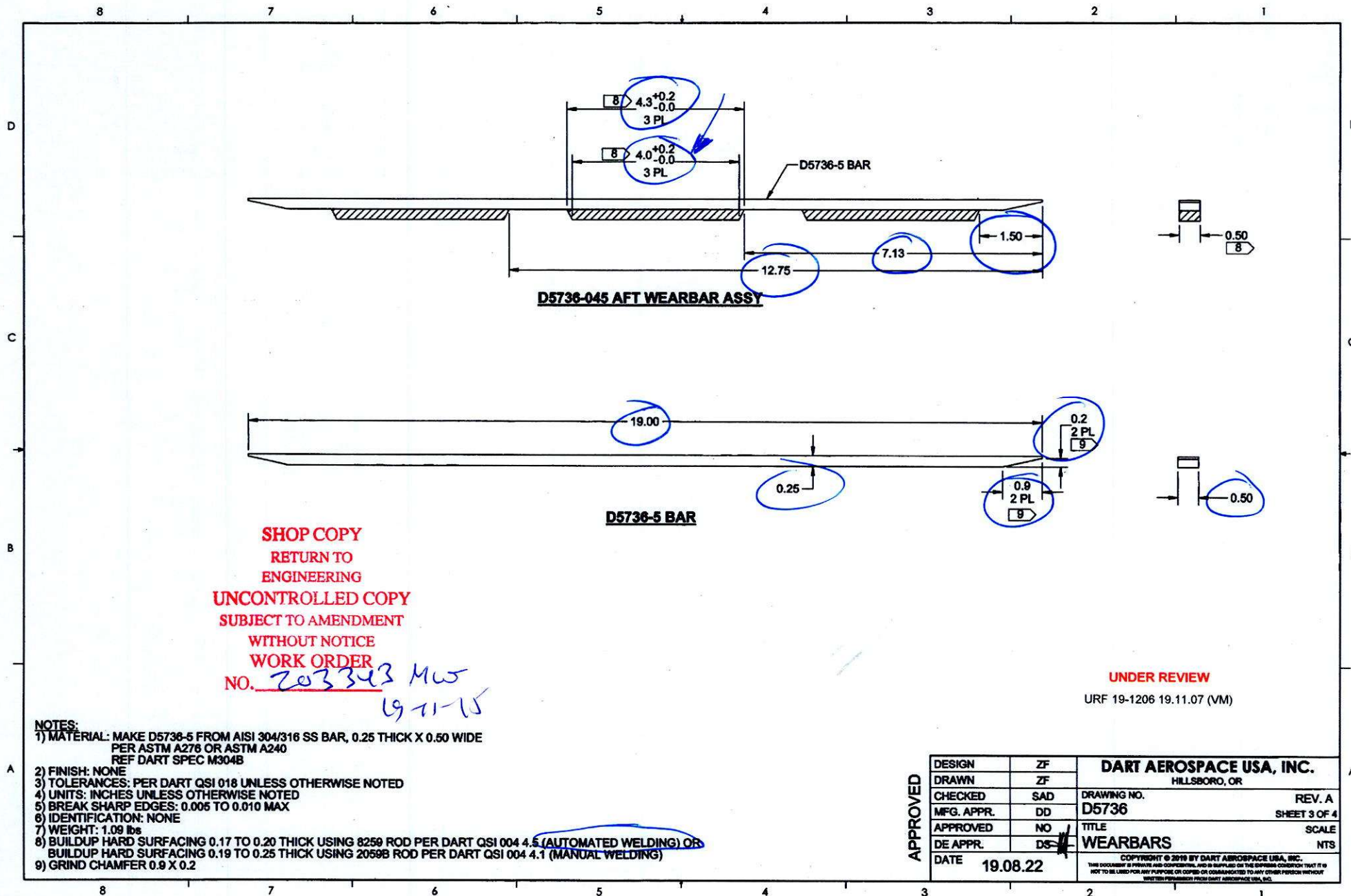
DAS
21
9-89

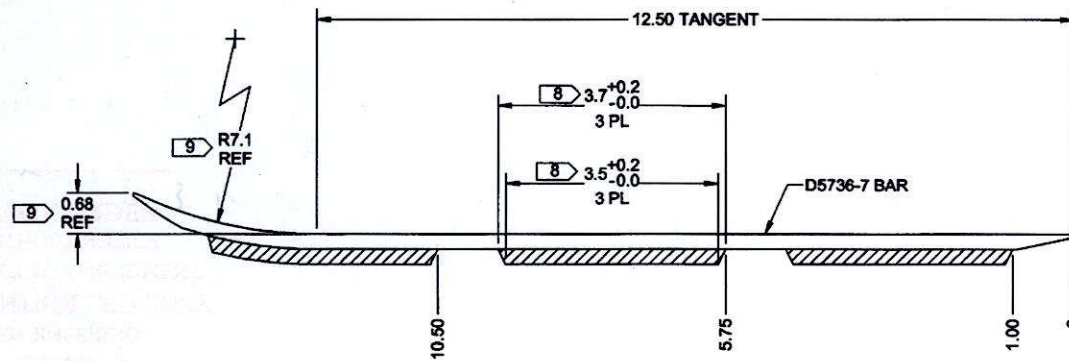
NOV 29 2019

Part Op 100 - (Large Fab) Cut D5736-5 at 21.50" (EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D5736-045)
 Descriptions: 110 - (Automated welding) 1-USE GRINDER TO CHAMFER END AS PER DWG . ***SEE NOTE 8 FOR SURFACE BUILDUP*** USE BT WELDING FIXTURE 8259- M139025
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: W608 LOCATION: WA002
 150 - (QC21- Final Inspection - Work Order Release)

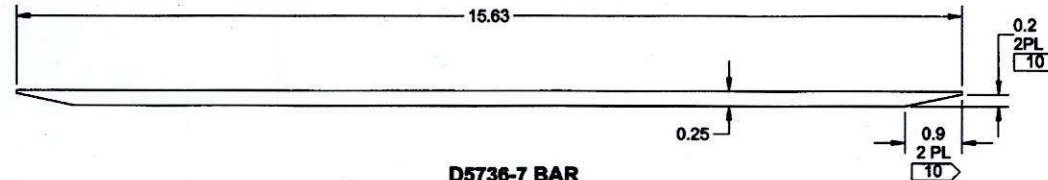
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304B0.250x0.500	304 Bar .250 X .500	3.4200 ft (1.71 ea)	100-Large Fab - Welded Assy-1	S227407
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	3	618	0
Part Specifications				
Specifications could not be found.				

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D5736-047 FWD WEARBAR ASSY



D5736-7 BAR

UNDER REVIEW

URF 19-1206 19.11.07 (VM)

NOTES:

- 1) MATERIAL: MAKE D5736-7 FROM AISI 304/316 SS BAR, 0.25 THICK X 0.50 WIDE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.92 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER DART QSI 004 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER DART QSI 004 4.1 (MANUAL WELDING)
- 9) FORM TO MATCH PROFILE OF D5735-7 WEARPLATE
- 10) GRIND CHAMFER 0.9 X 0.2

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	SAD	DRAWING NO.	REV. A
MFG. APPR.	DD	D5736	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	WEARBARS	NTS
DATE	19.08.22	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>203343</u> Part No. <u>DS736-045</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : <u>19.12.11</u>	Sequence #: <u>100</u>	QTY Affected : <u>1</u>		MRB (QSI042)
Description Work Order Deviation		Disposition		<u>NO</u> 19.12.11 Completed By <u>NO</u> 19.12.11 Lead hand / Supervisor QC / QA Coordinator
Weld size dimension is under tolerance 4.3" $\pm .000$ is 4.250"		welds acceptable as is dwg tolerances will be revised to match achievable manufacturing tolerance		
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☒ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
		Other/Details:		

